








Deren 55705

Work Order ID 53378


November 03, 2009 8:35:10 AM





Item ID: D3175-041 Accept  Setup Start 
Revision ID: A Stop 
Item Name: Mounting Lug
Start Date: 11/3/2009 Start Qty: 6.00  Cust Item ID:
Required Date: 11/6/2009 Req'd Qty: 6.00  Customer:
Reference:

Approvals: Process Plan: MF Date: 09-11-02 Tooling: Date: Run Start 
QC: Date: SPC (Y/N): Date: Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3175	Rev A								

100 0.00
 BAND SAW
Bandsaw Memo 0.00
Jeaspa Bandsaw (2) blanks required per (1) D3175-041 assembly ☐ Cut blanks: 2.5" x 1.5" x 2.2" (grain along 2.2")
MF 09/11/07 6 x 2

110 0.00
 HAAS CNC VERTICAL MACHINING #1
HAAS I Memo 0.00
HAAS CNC vertical machine #1 Machine as per Folio FA293 and Dwg D3175 ☐ Deburr and Tumble ☐ Identify as D3175-1
MF 09/11/17 6 x 2

120 0.00
 QC2- Inspect parts off machine FAI/FAIB
QC Memo 0.00
Quality Control MF 09/11/17 6 x 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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November 03, 2009 8:35:10 AM



Page 2

Item ID: D3175-041

Accept



Setup Start



Revision ID: A

Item Name: Mounting Lug

Stop



Start Date: 11/3/2009 Start Qty: 6.00



Cust Item ID:

Required Date: 11/6/2009 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

mt 09/11/18

6 0

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

241 09/11/18

(X12) 0

Hand Finishing

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

BR 09-11-18

(12)

Quality Control

W/O:		WORK ORDER CHANGES					
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Work Order ID 53378

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Page 3

Item ID:	D3175-041	Accept		Setup	Start	
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Item Name:	Mounting Lug					
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Required Date:	11/6/2009	Req'd Qty: 6.00		Customer:		
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 	Small Fab	0.00							
Small Fab	Memo	0.00							
Small Fab	Assemble as per Dwg D3175								
170 	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									
180 	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
Powdercoat	Memo	0.00							
Powder Coating	START TIME: 9:00 AM OVEN TEMPERATURE: 320°F								
	FINISH TIME: 9:30 AM								

Handwritten signature and date: 11/06/09 (6)

Handwritten note: 2) 8.10.01.05

Handwritten circled number: 16

Handwritten note: => 11 09-05-01

Handwritten circled number: 16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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November 03, 2009 8:35:10 AM

Page 4

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Revision ID: A

Item Name: Mounting Lug

Start Date: 11/3/2009 Start Qty: 6.00

Required Date: 11/6/2009 Req'd Qty: 6.00

Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC3- Inspect Part Finish

0.00

10-01-5

(6)



QC

Memo

0.00

Quality Control

200

Identify as per dwg & Stock Location: 40

0.00



Packaging

Memo

0.00

Packaging

10/01/06 (6)

210

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/01/06
MF 10-01-06

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NOTE: Date & initial all entries

Picklist Print

November 03, 2009 8:35:10 AM

Page 1

Work Order ID: 53378

Parent Item: D3175-041RevA

Parent Item Name: Mounting Lug

Comments:


Start Date: 11/3/2009

Required Date: 11/6/2009

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

AN3-7A  Bolt		Purchased	No			160	Each	57.0000	12.0000			
---	--	-----------	----	--	--	-----	------	---------	---------	--	--	--

Warehouse Loc Qty Loc Code


Location

Main Warehouse

ST 57

110704 2

111127 55

AN960JD10L  Washer		Purchased	No			160	Each	5,735.000	24.0000			
---	--	-----------	----	--	--	-----	------	-----------	---------	--	--	--

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 5735


101291 16

104885 153

105793 236

109632 420

110985 4910

D3175-3RevA  Spacer		Manufactured	No			160	Each	15.0000	6.0000			
--	--	--------------	----	--	--	-----	------	---------	--------	--	--	--

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 15

25027 15

B53814 (4x)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

November 03, 2009 8:35:10 AM

Page 2

Work Order ID: 53378

Parent Item: D3175-041RevA

Parent Item Name: Mounting Lug

Comments:

Start Date: 11/3/2009

Required Date: 11/6/2009

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6B1.500X02.50 0		Purchased	No			160	f	104.5115	1.2101			



6061-T6 Bar 1.50 x 2.50

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	104.5115	
103069	12	
107387	70	
16716 ←	20.7115	
16742	1.8	

MS21042L3

Purchased

No

100

Each

3,286.000

12.0000



Nut

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	3286	
110844	32	
111274	29	
111668	725	
112314	2000	
112385	500	

1.2101 - ml 09/11/18

EP 10/01/04

12

November 03, 2009 8:35:10 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

D3065-5DART AEROSPACE LTD		Work Order:	53378
Description: Bracket		Part Number:	D3175-1
Inspection Dwg: D3175	Rev: A	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.191	+0.005/-0.000	Ø.193	✓			
Ø0.316	+0.005/-0.000	Ø.316	✓			
R0.25	+/-0.030	R.250	✓			
0.713	+/-0.010	.713	✓			
0.125	+/-0.010	.125	✓			
2.130	+/-0.010	2.132	✓			
1.000	+/-0.010	1.000	✓			
0.125	+/-0.010	.122	✓			
1.730	+/-0.010	1.734	✓			
0.700	+/-0.010	.700	✓			
0.500	+/-0.010	.498	✓			
2.000	+/-0.010	1.999	✓			
1.000	+/-0.005	1.000	✓			

Measured by: <i>[Signature]</i>	Audited by: <i>[Signature]</i>	Prototype Approval:	N/A
Date: 09/11/17	Date: 09/11/18	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.02.25	New Issue	P/O D3175-041	KJ/RF <i>[Signature]</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

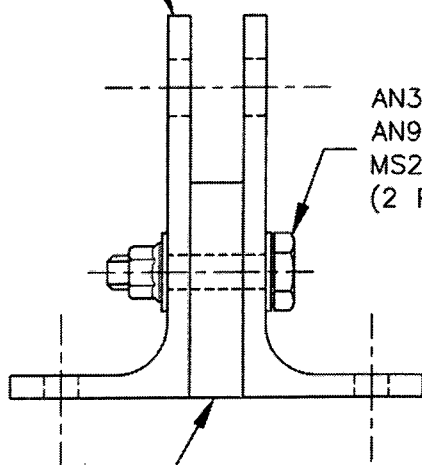
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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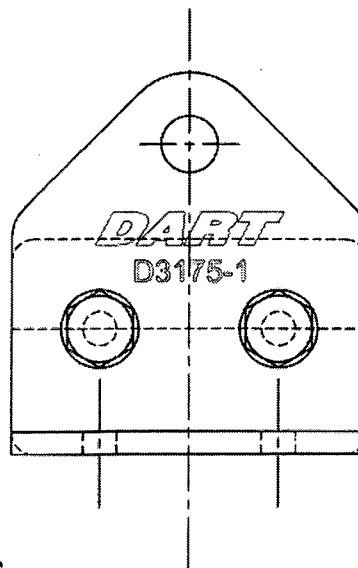
NOTE: Date & initial all entries

DART

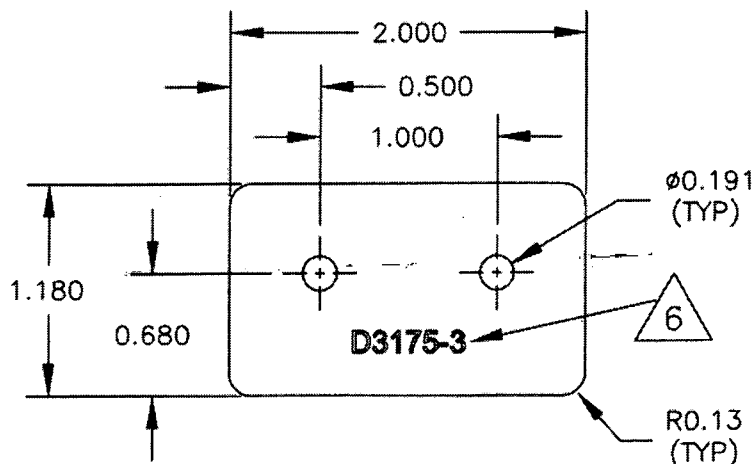
DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3175	REV. A SHEET 1 OF 2
DATE 02.12.03		TITLE MOUNTING LUG	SCALE 1:1
A	02.12.03	NEW ISSUE	

D3175-1
(2 PLACES)AN3-7A BOLT (1)
AN960JD10L WASHER (2)
MS21042L3 NUT (1)
(2 PLACES)

#53378



D3175-3

D3175-041 MOUNTING LUGFINISH: POWDER COAT ASSEMBLY WHITE (4.3.5.1)
PER DART QSI 005 4.3RELEASED
02.12.03 #**D3175-3 SPACER**

- 1) MATERIAL: 6061-T6 ALUMINUM, 0.285 TO 0.290 THICK
(QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8)
(REF DART SPEC. M6061T6B)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) ENGRAVE P/N IN THIS AREA AS SHOWN TO A DEPTH OF 0.010 MAX

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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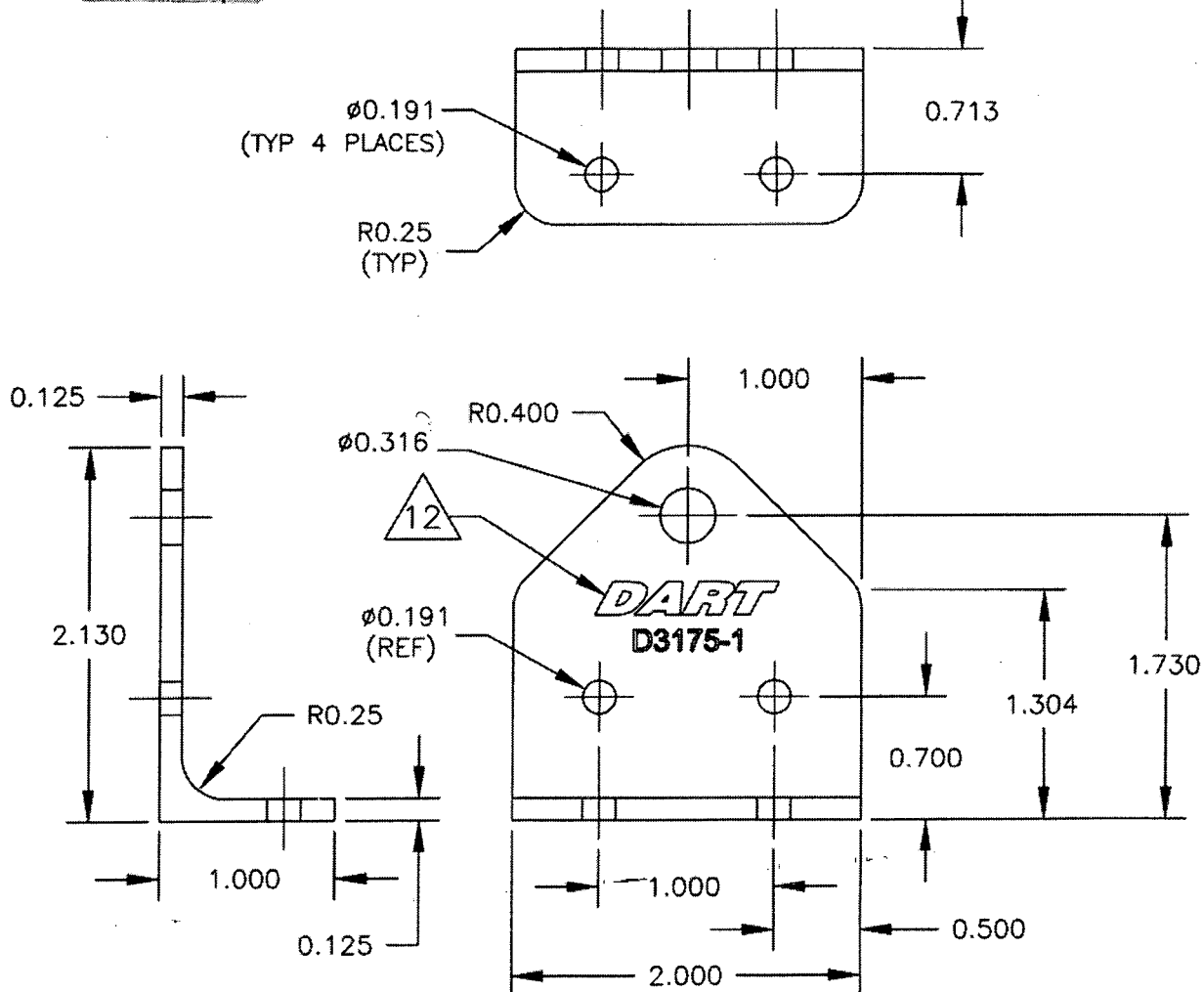
NOTE: Date & initial all entries

DART

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3175	REV. A SHEET 2 OF 2
DATE 02.12.03		TITLE MOUNTING LUG	SCALE 1:1

RELEASED
02.12.03

#53378

**D3175-1 BRACKET**

7) MATERIAL: 6061-T6 ALUMINUM (QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8)
(REF DART SPEC. M6061T6B)

8) BREAK ALL SHARP EDGES 0.005 TO 0.015

9) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

10) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

11) ALL DIMENSIONS ARE IN INCHES

12) ENGRAVE DART LOGO & P/N IN THIS AREA AS SHOWN TO A DEPTH OF 0.010 MAX

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